

✓ Date: Monday, 5/15/2006 11:12:00 AM
✓ User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STA 155 BRACKET		
Job Number	: 27112						
Estimate Number	: 11039						
P.O. Number	: N/A			Part Number	: D28041		
This Issue	: 5/15/2006	S.O. No.	: N/A	Drawing Number	: D2804 REV B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: 5/15/2006	Type	: SMALL /MED FAB	Drawing Revision	: B		
Previous Run	: 26164			Material	: N/A		
Written By	<u>See JAC comment below</u>			Due Date	: 5/30/2006		
Checked & Approved By	<u>JAC 06.05.15</u>				Qty:	20	Um: Each
Comment	: Est. A00.11.06 New Issue EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0" 
	Comment: Qty.: 0.7875 f(s)/Unit Total : 15.7500 f(s)	M9878 (1 piece). 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"
2.0	BAND SAW	BAND SAW 
	Comment: BAND SAW Cut blanks per template DT8534	SD 06.05.25 20
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	SD 06.05.25 20
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SD 06.05.25 20
5.0	QC8	SECOND CHECK 
	Comment: SECOND CHECK	SD 06.05.30 20
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr	SD 06.05.31 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:12:00 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

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Part Number: D28041

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 159

16/6/02 : (20) 06/06/03

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

16/6/02 : (20) 06/06/03

Job Completion



W 06/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27112
Description: Bracket	Part Number:	D2804-1
Inspection Dwg: D2804 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SD
Date:	06-05-25

Audited by:	J.G
Date:	06/05/25

Prototype Approval:	N/A
Date:	N/A

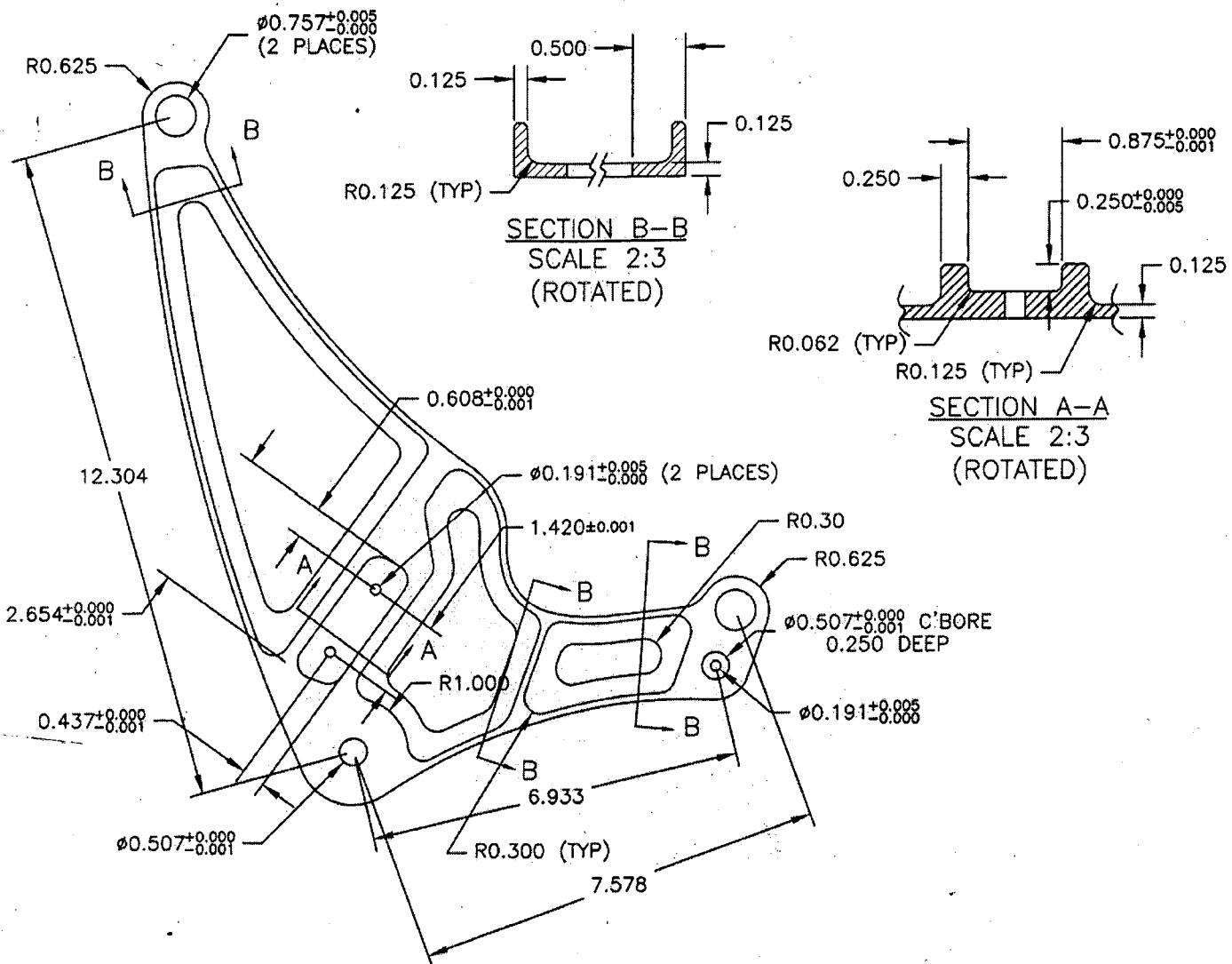
Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	SJL

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 -



D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 T
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 271112

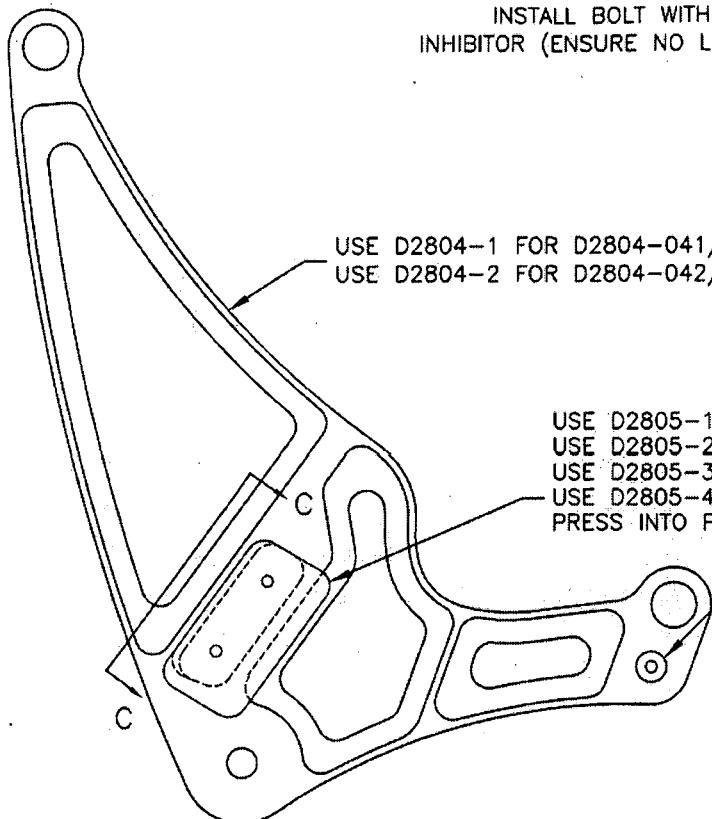
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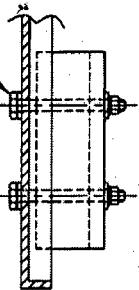
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041

USE D2805-2 FOR D2804-042

USE D2805-3 FOR D2804-043

USE D2805-4 FOR D2804-044

PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

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05-03-11 *[initials]*

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WORK ORDER

NO. *27112*

D2804-041/-043 BRACKET ASS'Y (SHOWN)

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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